

Work Order ID 86047

June-19-12 4:10:50 PM

86047

Page 1

Item ID: D4006-04

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Top Support Assembly

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *WLS*

Date: *12/06/20* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4006	B

100 0.00

100

Small Fab Memo 0.00
Small Fab Assemble as per dwg D4006

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00
Quality Control

120 Gloss Grey (4.3.5.15) per QSI 005 4.3 0.00

120

Powdercoat Memo 0.00
Powder Coating
Start Time: *11:00*
Oven Temperature: *320°F*
Finish Time: *11:30*

DAS 16

12/4/25

(70)

mt

2X

12/07/25

118533
WLS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

2 0 012725..

140

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Apply glue and install Foam as per dwg
3M 1300L Batch: 17122306
2- Install anchor nuts as per dwg

2 0 12/08/02

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

SMB
12-7-07
DGM
12/08/02

2

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

57242

0.00

Packaging

12/8/7 (2)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/8/7

MW 12/08/07

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:10:54 PM

Page 1

Work Order ID: 86047

86047

Parent Item: D4006-041

D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 *D4006-1* Angle		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				8					
					80022			8					
D4006-3 *D4006-3* Channel		Manufactured	No			100	Each	6.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				6					
					80627			6					
MS20470AD4-5 *MS20470AD4-5* Rivet, Universal Head		Purchased	No			100	Each	1,246.000	8	32			
				<u>Location</u>				<u>Loc Qty</u>					
				ST319				1246					
					116410			18					
					118405			405					
					120142			823					
D4006-5 *D4006-5* Foam		Manufactured	No			140	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST082				6					
					80023			6					

Handwritten notes and signatures:

- Signature: [Signature]
- Date: 12/07/25
- Signature: [Signature]
- Date: 12/07/25
- Signature: [Signature]
- Date: 12/07/25
- Signature: [Signature]
- Date: 12/08/02
- Signature: [Signature]
- Date: 12/08/02

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

86047

D4006-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-4

Purchased

No

140

Each

2,750.000

4

16

MS20426AD3-4

RIVET

**

EB 12/08/02

Location

Loc Qty

Loc Code

ST316

2750

104374

236

110398

2514

MS21059L4

Purchased

No

140

Each

59.0000

2

8

MS21059L4

Nutplate

**

EB 12/08/02

Location

Loc Qty

Loc Code

ST301

8

117887

3

119623

5

ST302

51

120930

1

121060

50

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

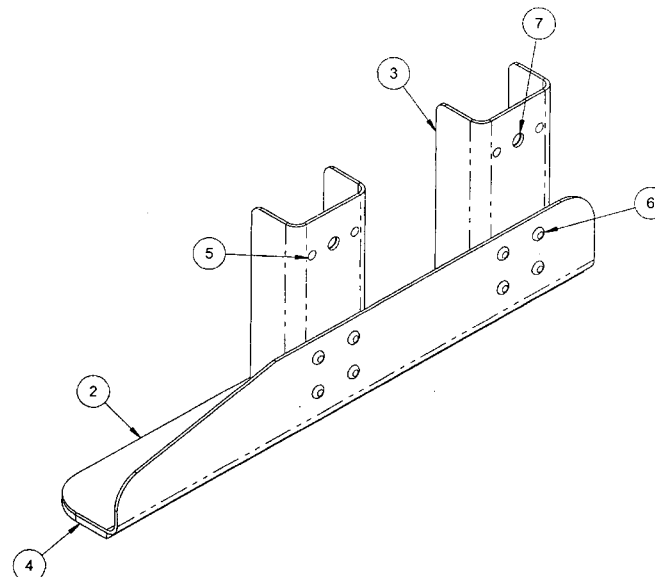
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3(-4)	RIVET	
6	8	MS20470AD4(-5)	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86047 MCT
12/06/20

RELEASED
2012-03-03
JWP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.48 lbs

B	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A7-1.	DC	12.02.28
A	NEW ISSUE	BY	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4006	SHEET 1 OF 6
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	UPPER RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

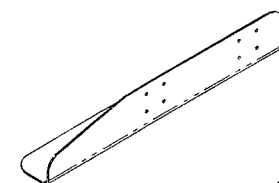
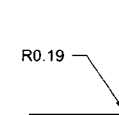
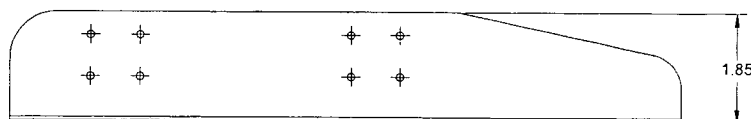
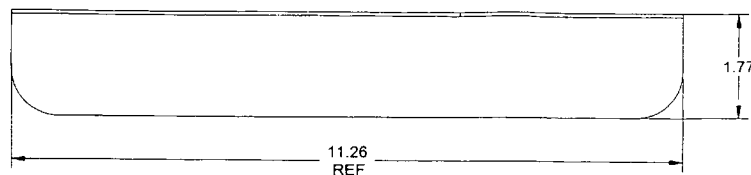
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



86047

D4006-1 ANGLE

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4006	SHEET 2 OF 6
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	UPPER RESTRAINT	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

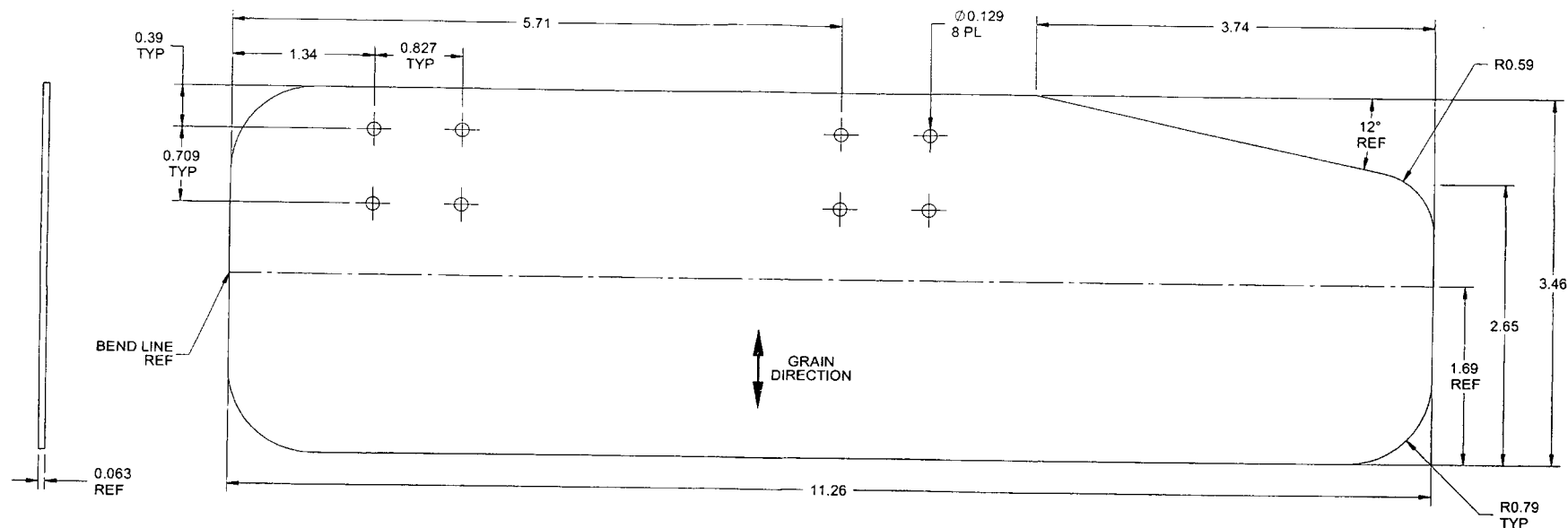
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86047



D4006-1F FLAT PATTERN

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4006	REV. B
MFG. APPR.	BC	SHEET 3 OF 6	
APPROVED	BC	TITLE UPPER RESTRAINT	SCALE
DE APPR.	BC	NTS	
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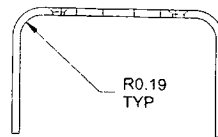
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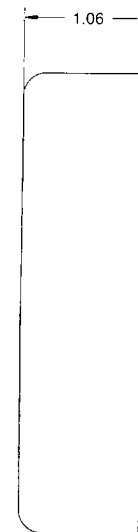
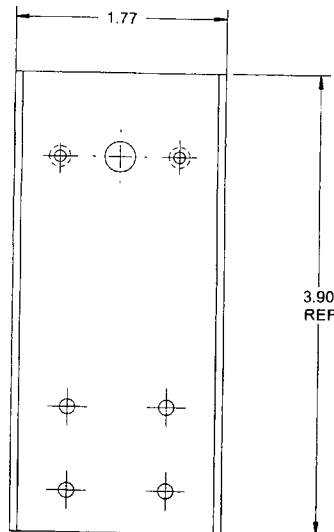
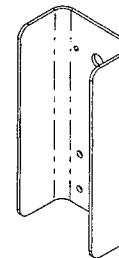
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-3	REF JCA-M47-2-01



86047



D4006-3 CHANNEL

RELEASED
2012-03-03
WPD

NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>BE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4006	SHEET 4 OF 6
APPROVED	<i>WPD</i>	TITLE	SCALE
DE APPR.	<i>WPD</i>	UPPER RESTRAINT	NTS
DATE	12.02.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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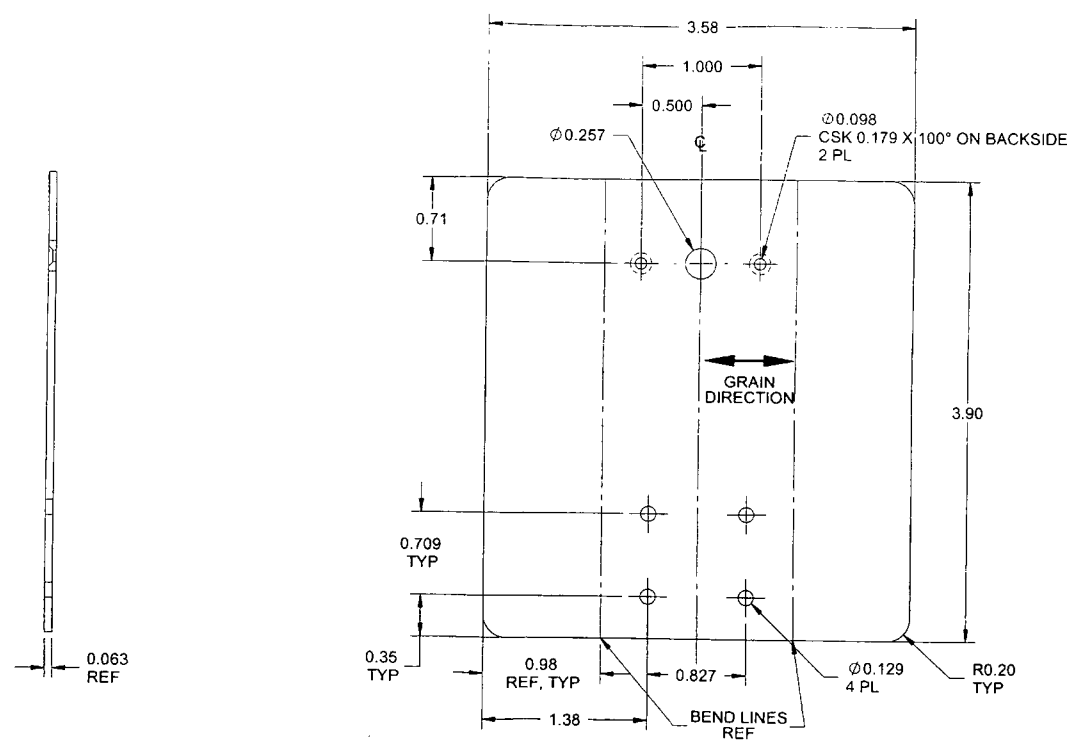
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NOTE: Date & initial all entries

26047



D4006-3F FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4006	SHEET 5 OF 6
APPROVED	MP	TITLE	SCALE
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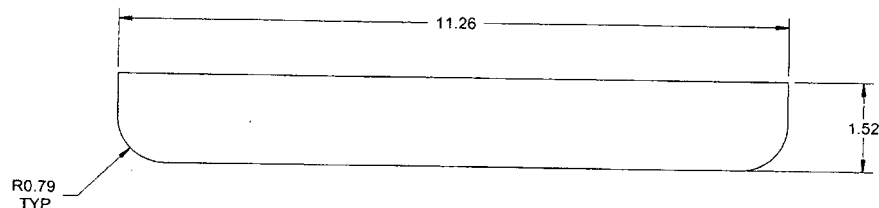
DART AEROSPACE
PART NUMBER

D4006-5

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01

86047



D4006-5 FOAM

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4006	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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